5/30

DART AEROSPACE LTD.	Work Order:	23802
Description: Saddle Fitting, Aft (Outboard/Inboard)	Part Number:	D2573/D2574
Drawing: D2573 Rev. D/D2574 Rev. D	Qty:	12
		Page 1 of 1

DC	Step		Procedure	By∧	Date	Qty
MV Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: 321819 342 6507/25 / 2 3 MV Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: 323249 MZ 6507/25 / 2 4 MV Fixturing W/O No. Fixturing linspection last completed by N/A Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets MW Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets MW Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets MW Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets MW Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets MW Subject of Subject	1	DC	Issue Traveller	12/1	A 07 1.1	1
Ensure that grain is along 7.75" length Batch No: 321819 3				10	03.07.14	16
Batch No: 32/3/9 Mode from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: 323249 Modo7/25/12 D007/25/12	2	MV	Make from D6101-007 billet for D2573			
Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length B2/3/24 MV Fixturing W/O No. Fixturing Inspection last completed by N/A				h .	1 1	
Ensure that grain is along 5.00" length Batch No: [32/3]-4 MV Fixturing W/O No. Fixturing inspection last completed by N/A Fixturing W/O No. Fixturing W/O No. Fixturing inspection last completed by N/A Fixturing W/O No. Fixturing W/O No. Fixturing inspection last completed by N/A Batch No: [32/3/29] M/A N/A Fixturing W/O No. Fixturing inspect per attached by w/O No. Fixturing inspect per attach			Batch No: <u>132/8/9</u>	Int	6507/25	12
Batch No: 13.23.249	3	MV	Make from D6101-005 billet for D2574			
Batch No: 13.23.249				_ 0	11	
Fixuring Inspection last completed by Program Batch No. 336000 Double check by: 20 B2 05.1.25 12 6 MV Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 7 MV Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 8 MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 9 MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 9 MV Machine Keyway as per dwg D2573 & D2574 10 MV Deburr and remove all machining marks 11 MV Tumble for 20 minutes for know sharp added for the of			Batch No: <u>1323</u> 24 9	Sut	05/07/25	12
Double check by: Double	4/	MV /		1	/ 61/0	/
Double check by: A Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 7 MV Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 8 MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 9 MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 9 MV Machine keyway as per dwg D2573 & D2574 10 MV Deburr and remove all machining marks 11 MV Tumble for 20 minutes to remote sharp adges flow 4.21 12 QC1 Inspect all dimensions to dimension sheets 13 QC7 Second inspection 14 FP Acid etch and alodine as per QSI 005 4.1 15 FP Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3 16 QC3 Inspect Powder Coat 17 ST Identify and Stock. DV 05/08/08 L2 19 DC Close W/O A 3, 20 / 7, 64					NIA	
MV Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine Keyway as per dwg D2573 & D2574 Machine Keyway as per dwg D2574 Machine Keyway as per dwg D2573 & Machine Keyway as per dwg D	5	M√	Program Batch No. 33802			
Dimension Sheets Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine Keyway as per dwg D2573 & D2574 Machine Keyway as per dwg D2574				156	O5.01.75	12
MV Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets MV Machine keyway as per dwg D2573 & D2574 MV CAC\$ 0.3 1.2	6	MV		an 1	1.1	
Dimension Sheets MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine keyway as per dwg D2573 & D2574 Machine keyway as per dwg D2573 & D2574 MV Deburr and remove all machining marks Machine keyway as per dwg D2573 & D2574 MV Deburr and remove all machining marks Machine keyway as per dwg D2573 & D2574 MV Oslos/03 12 10 MV Deburr and remove all machining marks Machine keyway as per dwg D2573 & D2574 MV Oslos/03 12 11 MV Tumble for 20 minutes to remove sharp 2 dges flog oslos 2 12 QC1 Inspect all dimensions to dimension sheets Machine keyway as per dwg D2573 & D2574 Machine keyway as per dwg D				116	0408102	12
8 MV Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets Machine keyway as per dwg D2573 & D2574 Machine keyway as per dwg D2574 Machine keyway as per dwg D2573 & D2574 Machine keyway as per dwg D2574 Machine keyway as	7	MV		and	1.1.1	
Dimension Sheets M2				11/6	05/08/03	12
9 MV Machine keyway as per dwg D2573 & D2574 10 MV Deburr and remove all machining marks 11 MV Tumble for 20 minutes to remove sharp 2 dges flog -0.2 1 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	8	MV	, , ,	500	10/10	
10 MV Deburr and remove all machining marks The color of col				112	05/08/03	12
10 MV Deburr and remove all machining marks	9	MV	Machine keyway as per dwg D2573 & D2574	In O	10/01/01	
11 MV Tumble for 20 minutes to remove sharp 2 dges 104.06.21 9 ml o 508/03 12 12 QC1 Inspect all dimensions to dimension sheets 9 ml o 508/03 12 13 QC7 Second inspection 16 05.08.04 12 15 FP Acid etch and alodine as per QSI 005 4.1 16 QC3 Inspect Powder Coat 17 ST Identify and Stock. DV 05/08/08 12 18 AC Cost / Part 1 5 2.93 1/6 , 00 1/7 .64 1/8				1.0	0308103	14
11 MV Tumble for 20 minutes for remove sharp 2 days 104.06.21 2	10	MV	Deburr and remove all machining marks	Inl	100/12/12	
12 QC1 Inspect all dimensions to dimension sheets	11	NA) /	Turnelle for 20 minutes do no 12 days 2 days 2 days	ļ	03100103	12
12 QC1 Inspect all dimensions to dimension sheets	11	IVIV	Tumble tot 20 minutes to remove sharp unges 104.66.21	and	00/08/00	. ,
13 QC7 Second inspection 36 05.08.03 12 14 FP Acid etch and alodine as per QSI 005 4.1 FF 05.08.04 12 15 FP Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3 M S G G I2 16 QC3 Inspect Powder Coat Di 05/08/08 I2 17 ST Identify and Stock. Di 05/08/08 I2 18 AC Cost / Part / S 2.93 1/6,00 Suc 05.08.09 12 19 DC Close W/O / S 3.20 1/7.69 12	10	001		'	030007	12
13	12	QCI	Inspect all differsions to differsion sheets	one	notolos	, ,
14 FP	13	007	Second inequation		030310-3	<i>'</i> ×
14 FP Acid etch and alodine as per QSI 005 4.1 FP 05.08.04 12 15 FP Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3 M 05.08.04 12 16 QC3 Inspect Powder Coat DL 05/08/08 12 17 ST Identify and Stock. DL 05/08/08 12 18 AC Cost / Part / 5 2.93 //6.00 540 5.08.09 //2 19 DC Close W/O / 5 3.20 //7.69	13	QC/	Second inspection	13/	05.08 3	12
15 FP Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3 16 QC3 Inspect Powder Coat 17 ST Identify and Stock. 18 AC Cost / Part / \$\int 2.93 \\ 1/6.00 \\ 19 DC Close W/O / \$\int 3.20 \\ 1/7.69\\ 17 ST Close W/O / \$\int 3.20 \\ 17 ST SUCCOSE OF 12	14	FP	Acid etch and alodine as per OSI 005.4.1	The same		134
16 QC3 Inspect Powder Coat 17 ST Identify and Stock. 18 AC Cost / Part / \$\int 2.93 16.00 19 DC Close W/O / \$\int 3.20 17.69	'-		Thesa eterraria areasine as per QO, 600 4.1	17	05.00,04	12
16 QC3 Inspect Powder Coat 17 ST Identify and Stock. 18 AC Cost / Part / \$\int 2.93 16.00 19 DC Close W/O / \$\int 3.20 17.69	15	FP	Powder Coat High Gloss White (4 3 5 1) per QSI 005 4 3	101	,	- 4
16 QC3 Inspect Powder Coat 17 ST Identify and Stock. 18 AC Cost / Part / \$\sum_{2.93}\$ //6,00 \$\sum_{3.20}\$ \(\sum_{17.69}\$\) 19 DC Close W/O / \$\sum_{3.20}\$ //7.69		1	The state of the s	M	os of the	10
17 ST Identify and Stock. 18 AC Cost / Part / 5 2.93 //6.00 547 05-08-09 /2 19 DC Close W/O / 5 3. 20 //7.69	16	QC3	Inspect Powder Coat		, ,	
17 ST Identify and Stock. 18 AC Cost / Part / 5 2.93 //6,00 547 05-08-09 /2 19 DC Close W/O / 5 3. 20 //7.69			· ·	100	05/08/08	12
18 AC $\frac{DV O5/08/08 U}{Cost/Part 152.93}$ 1/6,00 $\frac{Suz}{19}$ DC $\frac{Close W/O / 53.20}{117.69}$	17	ST	Identify and Stock.			
18 AC Cost / Part / 5 2.93 //6,00 Sur 05-08-09 /2 19 DC Close W/O /3 3, 20 //7.69				DV	05/08/08	1)
Cost / Part / S 2.93	18	AC				
19 DC Close W/O /3 3, 20			Cost / Part 1 2.93 //6,00	SUT	05-08-09	12
Inspection Level 21 95/08/pg 7.2	19	DC	Close W/O /3 3, 20 1/7.64			
			Inspection Level 21	12	05/08/09	12

Rev	Date	Change	Revised By	Approved
D	99.09.09	Added inspection level, Qty column	EC	
E	00.07.04	Removed P/O for powder coat, drawing change rev. C	EC	
F	00.07.20	Removed inspection level 7	EC	1
G	01.04.27	Added D6101-007 & step 8	EC	\mathcal{A}
H	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2574	KJ TAT	\mathcal{A}



77